



Dart Aerospace Ltd.
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10018

SWA3-3

Job Sheet 194297



Part No: SWA3-3

Job Qty: 1 pcs

Part Name: Electric Swivel 3,000 lb Safe Work Load (1,360 Kg)



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/30/19

Job Tracking No:

Due Date: 5/13/19

Created By: Marie Lajeunesse

Type: SOLD

Description: Order 15785

Note: DWG SWA3-3 Rev 3 IPP Rev A 18.02.13 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	External Load - 1	1 pcs	5/13/19		0.00	2.00	External Load - 1		Michel
							External Load - 2		
							External Load - 3		
110	External Load - 2 - B4B	1 pcs	5/13/19		0.00	2.00	External Load - 1 - B4B		Michel
							External Load - 2 - B4B		
							External Load - 3 - B4B		
120	QC 5	1 pcs	5/13/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
125	DC - 1 - B4B	1 pcs	5/13/19		0.00	0.00	DC - 1 - B4B		
							DC - 2 - B4B		
130	Packaging 3-1 - Stock - B4B	1 pcs	5/13/19		0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		

DAS 30 9-89

MAY 29 2019

Plex 4/30/19 9:08 AM Dart.lajeunesse.marie



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Container No: S184314



Part: SWA3-3

Job No: 194297

Serial No/Batch: S184314

Revision: 3

Inspector:

Exp Date:

Instructions:

Date: 05/27/19

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QS1042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140 QC 21 - FG	1 pcs	5/13/19	0.00 0.00	QC 21 - FG - 21	
				QC 21 - FG - 70	
				QC 21 - SA - 53	

Part Op 100 - (Small Fab) -Assemble as per DWG. Sheet 1 ***All assembly to be done in accordance with SWA3 swivel manual***

Descriptions: Engrave T/N And / or S/N number as required Using Marktronic engraver as per DWG. Laser engrave dart logo as per DWG.

110 - (Small Fab) -Assemble as per DWG. Sheet 1 ***All assembly to be done in accordance with SWA3 swivel manual***

Engrave T/N And / or S/N number as required Using Marktronic engraver as per DWG. Laser engrave dart logo as per DWG.

120 - (QC5- Inspect part completeness to step on W/O)

125 - (Document Control) Photocopy blue file OM & OOPM-SWA3A Rev3

130 - (Identify as per dwg & Stock Location:) Bag and tag

140 - (QC21- Final Inspection - Work Order Release)

Entered: _____ Date: _____



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Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread		Other/Details:			

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
188-FPSS-832-1/4	Set Screw	1 Ea (1 ea)	100-External Load - 1	5165060
92210A303	Flat Socket Cap Screw	4 pcs (4 ea)	110-External Load - 2 - B4B	5083914
EL-PLUG-F	3-Prong Female Spade Plug	1 Ea (1 ea)	110-External Load - 2 - B4B	5175986
EL-PLUG-M	3-Prong Male Spade Plug	1 Ea (1 ea)	110-External Load - 2 - B4B	5175987
EL314-SJTOW	Long Line Electrical Wire, 14/3 Gauge replace w/t 01004-08-047	6 ft (6 ea)	110-External Load - 2 - B4B	5179682
SWA3-100	Upper End - Swa3 Swivel	1 pcs (1 ea)	110-External Load - 2 - B4B	5174084
SWA3-200	Lower End	1 pcs (1 ea)	110-External Load - 2 - B4B	5169352
SWA3-300	Wire Clamp	2 pcs (2 ea)	110-External Load - 2 - B4B	5173676
SWA3-400	Button Head Screw	2 pcs (2 ea)	110-External Load - 2 - B4B	5176939
SWA3-500B	Contact Spacer	1 pcs (1 ea)	110-External Load - 2 - B4B	5174896
SWA3-600	O-Ring	1 pcs (1 ea)	110-External Load - 2 - B4B	5176842
SWA3-700	Bearing Balls - 1/4"	32 Ea (32 ea)	110-External Load - 2 - B4B	5179121
SWA6A-1900	1/4" Female Spade Connector	6 Ea (6 ea)	110-External Load - 2 - B4B	5175992
SWA6A-900B	Rotary Connector - 3 wire	1 Ea (1 ea)	110-External Load - 2 - B4B	5172449

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-External Load - 1	188-FPSS-832-1/4	1	113	0
110-External Load - 2 - B4B	92210A303	4	56	0
	EL-PLUG-F	1	26	0
	EL-PLUG-M	1	57	0
	EL314-SJTOW - 01004-08-047	6	0	0
	SWA3-100	1	24	0
	SWA3-200	1	13	0
	SWA3-300	2	45	0
	SWA3-400	2	14	0
	SWA3-500B	1	12	0
	SWA3-600	1	15	0
	SWA3-700	32	824	0
	SWA6A-1900	6	283	0
	SWA6A-900B	1	14	0

Part Specifications

Specifications could not be found.

Loctite 242 (M138933)
 Grease Aeroshell No.7 (5138964)
 Silicone grease (M139008)

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Entered: _____ Date: _____



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			Completed By		
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Other/Details: _____					

Work Order 194297Customer 15785Number of Wires 3Date 2019-5-27Serial Number 5184314

Number of Cycles	Load (Lbs.)	Action	Pass/Fail
1	3,000	Check for Conductivity against all wires.	- Pass
1	3,000	Check all wires for grounding against swivel body.	- Pass
1	1,500	Check for Conductivity against all wires.	- Pass
1	1,500	Check all wires for grounding against swivel body.	- Pass
1	750	Check for Conductivity against all wires.	- Pass
1	750	Check all wires for grounding against swivel body.	- Pass
1	0	Check for Conductivity against all wires.	- Pass
1	0	Check all wires for grounding against swivel body.	- Pass

Test Conducted By:

Michel Lalonde

Technician

Signature:

Sylvie Boucher

QC 5 Small FAB / QA

Submit